

Work Order ID 51404

August 21, 2009 9:25:09 AM



Page 1

Item ID: D206-547-043 **BK**

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 8/21/09 Start Qty: **6** ~~4.00~~

Cust Item ID:

Required Date: 9/07/09 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: **CY**

Date: **09/08/21** Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-547	Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4! 12-Debur

EP 09/09/24 **6 RH**
6 LH

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-547! 12-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

EP 09/09/25 **6**

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 09/09/25

6 RH
6 LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51404

August 21, 2009 9:25:09 AM

Page 2

Item ID: D206-547-043

Accept

Revision ID: F

Item Name: Console High Slope

Start Date: 8/21/09 Start Qty: 4.00

Required Date: 9/07/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

Large Fab

Memo

1-Tack weld as per Dwg D206-547 A/R

Batch: M108436

0.00

0.00

AL ROD

09-10-01

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 80910101

862H
864H

150



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

Memo

0.00

0.00

⇒ 80910101

862H
864H

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51404

August 21, 2009 9:25:09 AM

Page 3

Item ID: D206-547-043

Accept

Revision ID: F

Item Name: Console High Slope

Setup Start

Stop

Start Date: 8/21/09 Start Qty: 4.00

Required Date: 9/07/09 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

09/10/02 6 LH
6 RH

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 09/10/02

66

180

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:00

OVEN TEMPERATURE:

3200

FINISH TIME:

1:30

09-10-5

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51404

August 21, 2009 9:25:09 AM



Page 4

Item ID: D206-547-043

Accept



Setup Start



Revision ID: F

Stop



Item Name: Console High Slope

Start Date: 8/21/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PCY/10/06 (4)

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPR
50089

PCY/10/06 (4)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/06

W09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 21, 2009 9:25:09 AM

Page 1

Work Order ID: 51404

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope

Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20470AD3-4		Purchased	No			100	Each	12,283.00	80.0000			
Rivet, Universal Head												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

12283

111477

8332

15541

3951

D2024RevU/R

Manufactured

No

110

f

0.0000

14.4000

Console Extrusion

D2602-1RevB

Manufactured

No

110

Each

1.0000

4.0000

Console Side, 206 Console

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

1

43752

1

B51779

6

EP 09/09/25

EP 09/09/25

EP 09/09/25

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 21, 2009 9:25:09 AM

Work Order ID: 51404

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope



Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2602-2RevB		Manufactured	No			110	Each	7.0000	4.0000			
												
Console Side, 206 Console												

EF 09/09/25

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

46249

1

Main Warehouse

ST177

6

50255

6

6

D2606RevA1

Manufactured No

110

Each

25.0000

4.0000



Console Bracket, 206/407 Console



EF 09/10/01

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

25

48442

25

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 21, 2009 9:25:09 AM

Work Order ID: 51404

Parent Item: D206-547-043RevF

Parent Item Name: Console High Slope

Comments:

Start Date: 8/21/09

Required Date: 9/07/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2607RevA1

Manufactured

No

110

Each

23.0000

4.0000



Bracket, 206 Console

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

32820

7

50327

16

Main Warehouse

ST38

16

MS20470AD3-3

Purchased

No

110

Each

8,658.000

32.0000



Rivet, Universal Head

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8658

1065

1435

16941

7223

August 21, 2009 9:25:09 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 5140402

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

990300 KE

MS20470AD3-4 RIVET
(TYP 18 PLACES)

D2601-1 SIDE (1) SHOWN
D2601-2 SIDE (1) OPPOSITE

D2709-1 RAIL (1) SHOWN
D2709-2 RAIL (1) OPPOSITE

D2709-3 RAIL (1) SHOWN
D2709-4 RAIL (1) OPPOSITE

- TRANSFER DRILL Ø0.098
FROM D2601 TO D2709
(TYP 18 PLACES)

D2605 BRACKET (1)

8.080
(REF)

MS20470AD3-3 RIVET
(TYP 10 PLACES)

D2607 BRACKET (1)

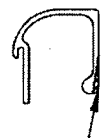
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WORK ORDER
NO. 544942

D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED KE	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY		SHEET 2 OF 5
		SCALE	1:4

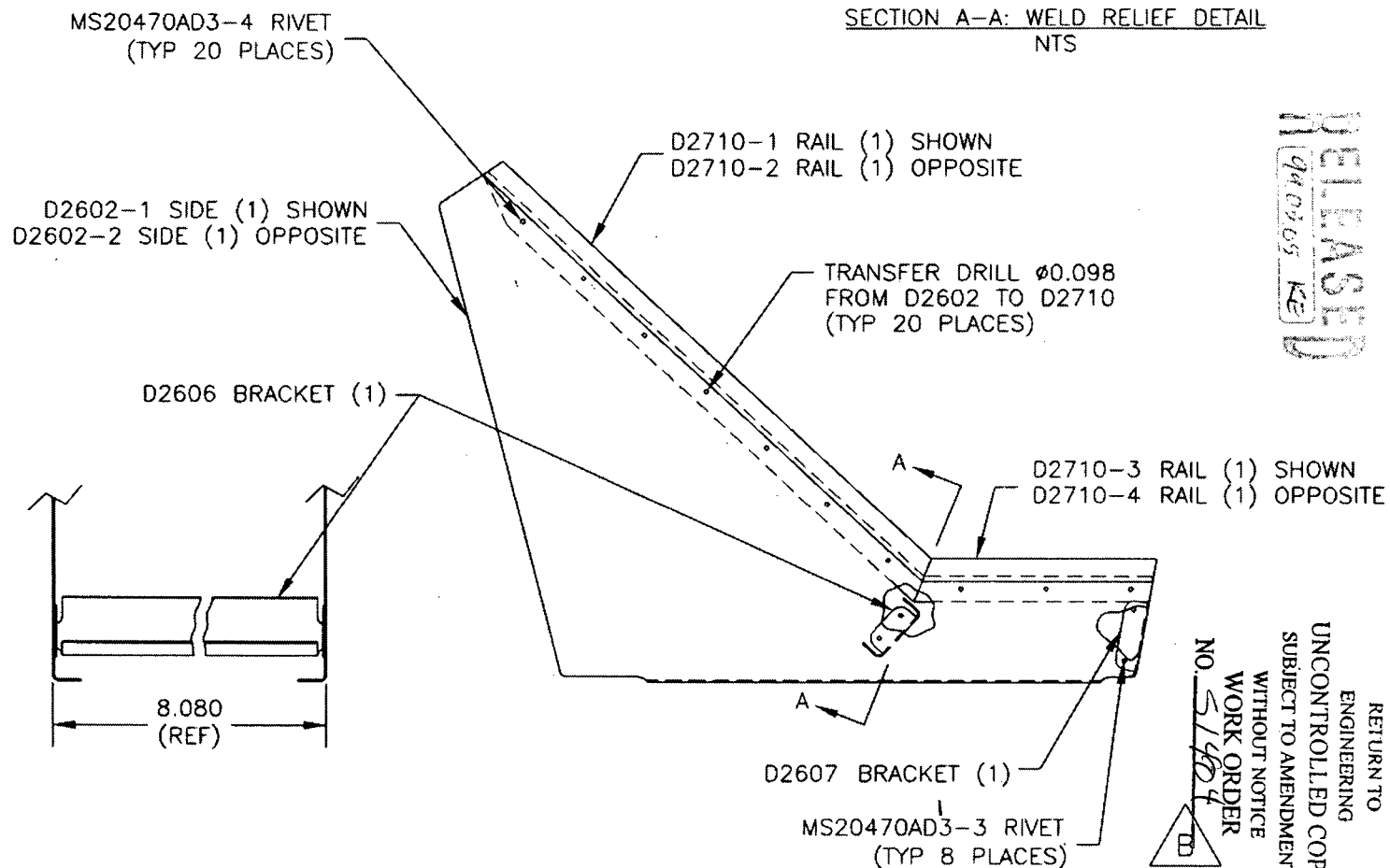
DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS

RELEASED
11 04 03 05 KE



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WORK ORDER
NO. 51404

D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN Bw	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED KE	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 3 OF 5	
		SCALE 1:4	

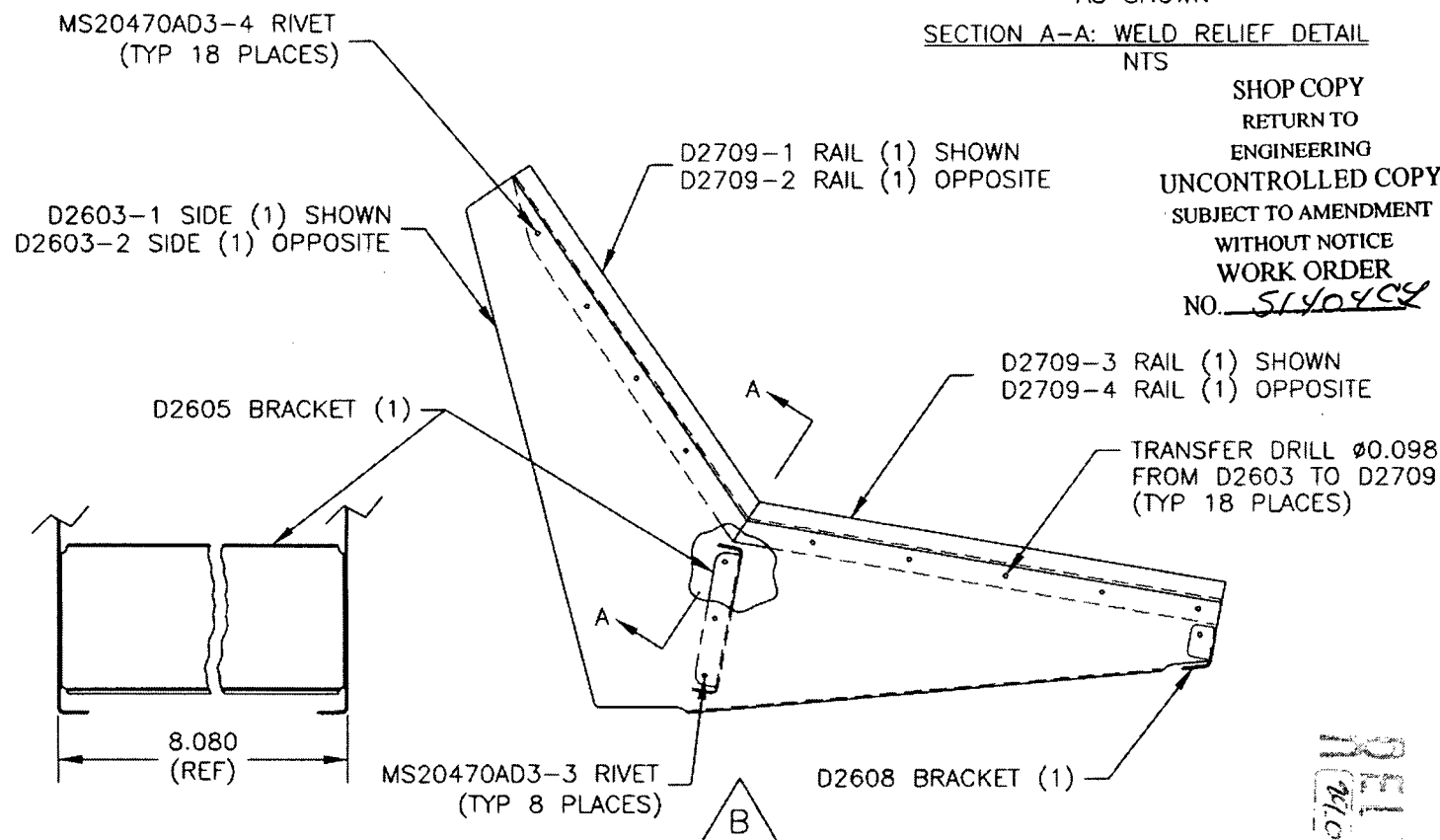
DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS

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WITHOUT NOTICE
WORK ORDER
NO. 51404C4



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

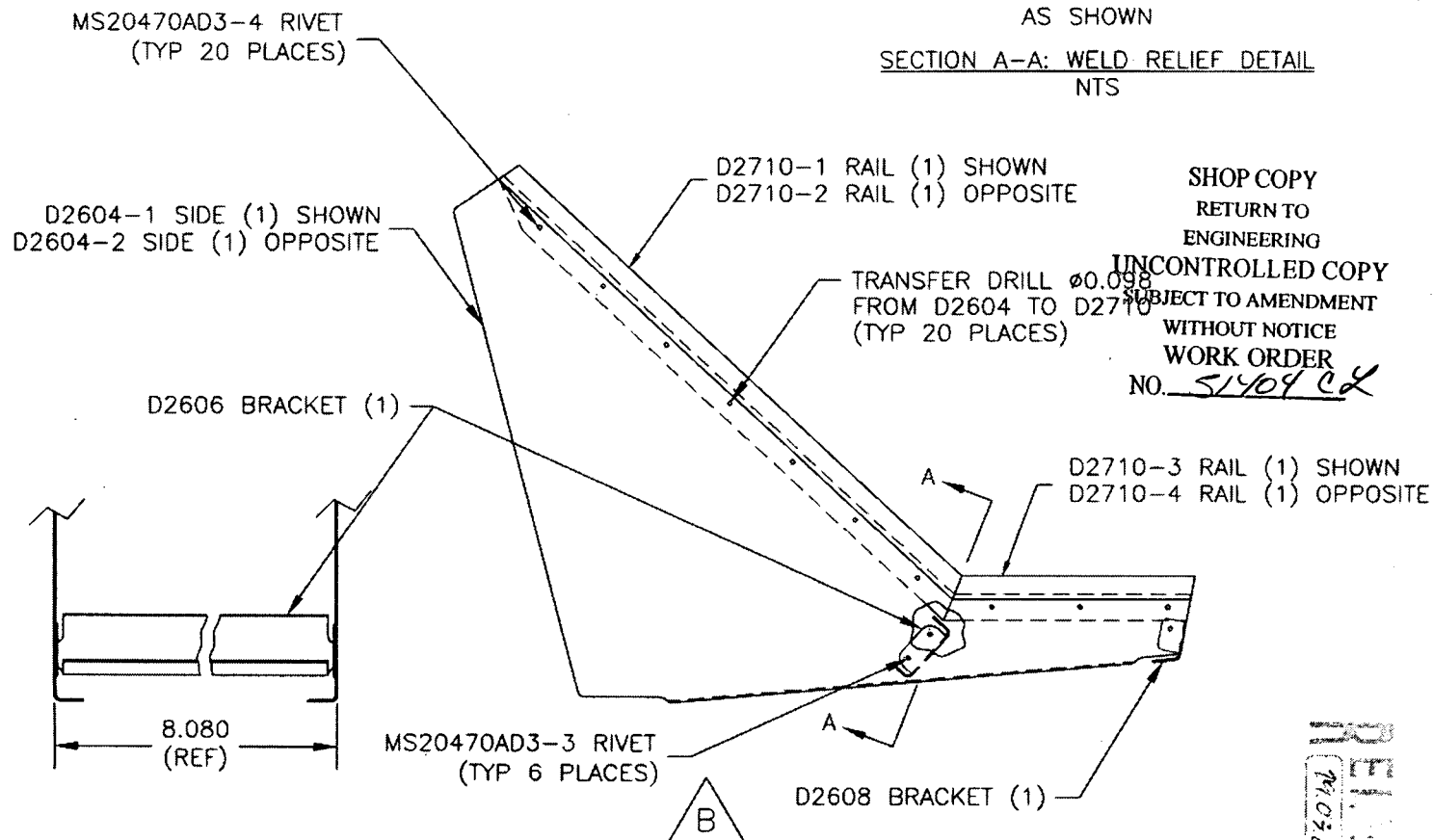
DESIGN	BW	DRAWN BY	RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	JP	APPROVED	AE	
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 4 OF 5
				SCALE 1:4

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



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SUBJECT TO AMENDMENT
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WORK ORDER
NO. 51404 C2

DESIGN Bw	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED UP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 5 OF 5
	SCALE 1:4	

RELEASED
11/03/05 KE

D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED